

Date: Thursday, 11/29/2007 11:04:06 AM
 User: Kim Johnston

Process Sheet

52

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: R44 CARGO MIRROR
Job Number	: 36024		
Estimate Number	: 10095		
P.O. Number	:	Part Number	: D044715011
This Issue	: 11/29/2007 S.O. No. :	Drawing Number	: D3243REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: A
Previous Run	: 34922	Material	: Manufacture in multiples of 10
Written By	:	Due Date	: 12/23/2007 Qty: 6 Um: Each
Checked & Approved By	: <u>Jim. 11 29</u>		
Comment	: Est Rev: A 04-02-18 New issue KJ/JLM Est Rev: B 06-04-28 Manufactured on Water Jet JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPPD044-715-011

CHG001

08/03/27

2.0	M6061T6S063	6061-T6 .063 Sheet
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Comment: Qty.: 0.5359 sf(s)/Unit Total: 2.6796 sf(s)

Material: 6061-T6 (QQ-A-250/11) 0.063" thick(M6061T6S.063)Identify for D3244-1

Batch: 105225 HB 07-12-5

3.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3243

Dwg Rev: A

Prog Rev: A

HB 07-12-5

6

2-Deburr if necessary

HB 07-12-5

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

HB 07-12-5

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

02/12/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/29/2007 11:04:07 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: R44 CARGO MIRROR

Job Number: 36024

Part Number: D044715011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3243

SP 08/03/13

(6)

7.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

5 08/03/14 (x6)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Chemical Conversion Coat as per QSI 005 4.1

M-H

08/03/17

(6x)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ml 08/03/24

10.0

FE032EF

Inserts



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 FE-032EF

Insert

M105385 x24

1 D3243-1(Ref)

Bracket

B36024 x6

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg d3243

ml 08/03/24 x6

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/24 (6)

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1-Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M-H

08/03/26

(6x)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: R44 CARGO MIRROR

Job Number: 36024

Part Number: D044715011

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08.03-26

(XC)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

16.0

D1048

Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

QtyPart Number Description Batch

2 D1048

Clamp

B30373

17.0

D1049

Saddle



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

QtyPart Number Description Batch

2 D1049

Saddle

B32797

18.0

D2010104

Mirror Arm 369/500



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick: Packing Kit

QtyPart Number Description Batch

1 D2010-104

Arm

34672

5X

37722

1X

19.0

D2011101

Mirror 6"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick: Packing Kit

QtyPart Number Description Batch

1 D2011-101

Mirror

35536

20.0

ALS41032130

Insert



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

QtyPart Number Description Batch

4 ALS4-1032-130Insert

B38108

PC 8/3/07 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 36024

Part Number: D044715011

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Seq. #:

Machine Or Operation:

Description :

21.0

AN34A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN3-4A

Bolt

M8912 2X

M103641

[Handwritten signature]

22.0

AN526C1032R10

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN526C1032R10

Screw

15072

[Handwritten signature]

23.0

AN960JD10L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD10L

Washer

M12747 8X

M104885 16X

8/3/27 *[Handwritten signature]*

24.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

8/08/03/27 *[Handwritten signature]*

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D044-715-011

Location: A

8/3/27 SP

[Handwritten signature]

26.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08 04.02

Job Completion



mf 08-03-28

[Handwritten signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

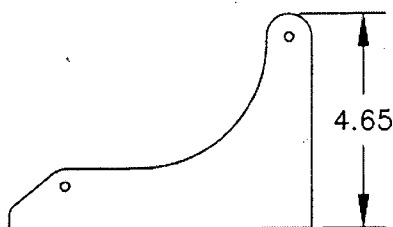
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3243	REV. A SHEET 1 OF 1
DATE 04.01.09		TITLE BRACKET	SCALE 1:2
A	04.01.09	NEW ISSUE	



R0.188 (TYP)



D3243-1 BEND DETAIL/
D3243-041 ASSEMBLY
SCALE 1:4

INSTALL
FE-032-EF INSERTS
(4 PLACES)

2.75 ± 0.030
0.000

RELEASED
04.02.03

8.581
8.206
7.706

GRAIN
DIRECTION

11.920
11.420

Ø0.201
(TYP 4
PLACES)

Ø0.290
(TYP 4
PLACES)

1.375

5.273

3.714

**D3243-041 BRACKET ASSEMBLY
(D3243-1 BRACKET)**

- 1) MATERIAL: 6061-T6, 0.063 THICK
(QQ-A-250/11, REF DART SPEC
M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT
PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER
DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO
0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

4.214
R0.25 (TYP)
3.339
R0.38 (TYP)

5.494

R2.75
(TYP)

D3243-1
FLAT PATTERN

R0.50
(TYP)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36024

0.500
0.000

0.750
0.500
0.000

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